



- a. Turn the thimble until the spindle contacts the anvil. If the micrometer has a ratchet stop, use it to ensure that the proper amount of pressure is applied.
- b. The adjustment is correct if the 0 mark on the thimble aligns exactly with the 0 mark on the sleeve line. If the marks do not align, the micrometer is out of adjustment.
- c. Follow the manufacturer's instructions to adjust the micrometer.

2B. To check a micrometer larger than 1 in. or 25 mm, use the standard gauge supplied by the manufacturer. A standard gauge is a steel block, disc or rod that is machined to an exact size.

- a. Place the standard gauge between the spindle and anvil, and measure its outside diameter or length. If the micrometer has a ratchet stop, use it to ensure that the proper amount of pressure is applied.
- b. The adjustment is correct if the 0 mark on the thimble aligns exactly with the 0 mark on the sleeve line. If the marks do not align, the micrometer is out of adjustment.

- c. Follow the manufacturer's instructions to adjust the micrometer.

Micrometer Care

Micrometers are precision instruments. They must be used and maintained with great care. Note the following:

1. Store micrometers in protective cases or separate padded drawers in a toolbox.
2. Make sure the spindle and anvil faces do not contact each other or another object while in storage. If they do, temperature changes and corrosion may damage the contact faces.
3. Do not clean a micrometer with compressed air. Dirt forced into the tool will cause wear.
4. Lubricate micrometers with WD-40 to prevent corrosion.

Telescoping and Small Bore Gauges

Use telescoping gauges (**Figure 33**) and small bore gauges (**Figure 34**) to measure bores. Neither gauge has a scale for direct readings. An outside micrometer must be used to determine the reading.

To use a telescoping gauge, select the correct size gauge for the bore. Compress the movable post and carefully insert the gauge into the bore. Carefully move the gauge in the bore to make sure it is centered. Tighten the knurled end of the gauge to hold the movable post in position. Remove the gauge, and measure the length of the posts with a micrometer. Telescoping gauges are typically used to measure cylinder bores.

To use a small-bore gauge, select the correct size gauge for the bore. Carefully insert the gauge into the bore. Tighten the knurled end of the gauge to carefully expand the gauge fingers to the limit within the bore. Do not overtighten the gauge, as there is no built-in release. Excessive tightening can damage the bore surface and damage the tool. Remove the gauge and measure the outside dimension (**Figure 35**). Small bore gauges are typically used to measure valve guides.

Dial Indicator

A dial indicator (A, **Figure 36**) is a gauge with a dial face and needle used to measure variations in dimensions and movements. Measuring brake rotor runout is a typical use for a dial indicator.

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